

Date: Thursday, 18/06/2009 7:29:32 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR SLUG
Job Number	: 48647		
Estimate Number	: 10162		
P.O. Number	:	Part Number	: D2587
This Issue	: 18/06/2009 S.O. No. :	Drawing Number	: D2587 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 46165	Material	:
Written By	:	Due Date	: 24/06/2009 Qty: 20 Um: Each
Checked & Approved By	: <u>C209/06/18</u>		
Comment	: Est D 04.05.31 Step 2 changed KJ/JLM Est E 06.07.31 Waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet
	Comment: Qty.: 0.0168 sf(s)/Unit Total: 0.3360 sf(s) 6061T6 alum. sheet 0.040" thick Batch: <u>100742</u> <u>B 9-6-18</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2587 Dwg Rev: <u>A1</u> <u>B 9-6-18</u> Prog Rev: <u>A1</u> 2-Deburr if necessary SB <u>SB 09/06/19</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-6-18</u>	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>S 02/06/19</u> <u>centus</u> <u>(66)</u>	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>umr 09/06/22</u> <u>(66)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



el



Comment: INSPECT ALODINE

09-09-22

(66)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 9/9/22 (64)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/22 *el*

Job Completion



MF
09-06-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

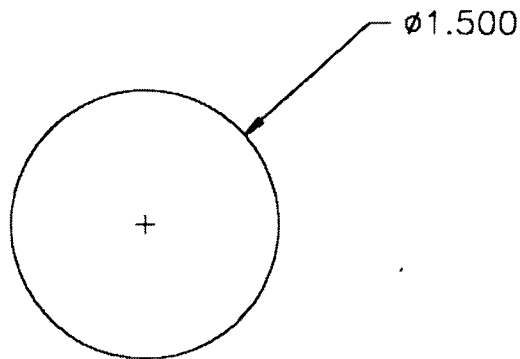
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED <i>MM</i>	APPROVED <i>MM</i>	D2587	SHEET 1 OF 1
DATE 96:07:11	TITLE DOOR SLUG		SCALE 1:1
AI <i>K</i> 03.09.16: ADD GCR-1-T6 OPTION			

RELEASED
16012311



C209/00118
W/O: 48647

OR GCR-1-T6 (GCR A 20078 OR GCR A-225/A) *AI*

MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ETCH, ALODINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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